



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3405-043
Job Sheet 179699



Part No: D3405-043

Job Qty: 12 ea

Part Name: Ground Handling Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP A 05.09.01 New issue KJ/JLM IPP B 09.01.28 Rev b dwg EC verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		7/18/18	0.00	0.00	Start Up Waterjet		SC 18/07/07
100	Waterjet	12 pcs		7/18/18	0.00	1.08	Waterjet1		SC 18/07/07
110	QC	12 pcs		7/18/18	0.00	0.00	QC2 Waterjet-2		SC 18/07/07
120	QC	12 pcs		7/18/18	0.00	0.00	QC8-2		38
130	Brake NC	12 pcs		7/18/18	0.09	0.87	Brake NC 1		9-89
140	QC	12 pcs		7/18/18	0.00	0.00	QC5		18-09-10
150	Large Fab	12 pcs		7/18/18	0.00	3.56	Large Fab 1		JBL
160	QC	12 pcs		7/18/18	0.00	0.00	QC9		62
170	QC	12 pcs		7/18/18	0.00	0.00	QC5		67
180	Powdercoat	12 pcs		7/18/18	0.00	0.33	Powdercoat2		lll 18-09-17
190	QC	12 pcs		7/18/18	0.00	0.00	QC3		38 AT 18/08/22
200	Packaging	12 pcs		7/18/18	0.00	0.00	Packaging3-1		509 800 AUG 7 2018
210	QC21-SA	12 Ea		7/18/18	0.00	0.00	QC21		21 AUG 24 2018

Part Op 100 - 1-Cut as per Dwg D3405 Dwg Rev: B Prog Rev: B 2-Debur if necessary
Descriptions: 130 - 1-Debur 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming
150 - Weld as per Dwg D3405 use DT8484 Identify as D3405-043
180 - START TIME: 7:15 AM OVEN TEMPERATURE: 325 °F FINISH TIME: 7:55 PM

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	1.8480 sf (.154 ea)	90-Start up Operation	
D3404-1	Ground Handling Wheel Lug	12 Ea (1 ea)	150-Large Fab	5055057705

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	2	28	0
150-Large Fab	D3404-1	12	53	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: Date:

Work Order update only

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
NCR No. _____	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation

Supervisor rification		Coordinator val	
ed By		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K8A 1K7 CANADA TEL: 1 613 692-5200 Email: sales@dartero.com www.darterospace.com	
DART AEROSPACE			
Order No: \$089845			
Part No: D3405-043			
Material No: 179699			
Batch: \$089845			
Location:			
Storage:			
Date:		Date: 07/09/18	
Instructions:			

Root Cause			Fault Category		
Environment	No Re-verification	Pressure/Forced			Wrong
Design	Operator	Bending			Dimensions
Doc/Data	Offset/Setup	Centre Not Conce			tolerance
Equip/Tooling	Supplier	Cracks			ct
Handling/Pre	Training	Crimp/Kink/Rippl			Part Lost, Missing
Material	Use for Testing	Cuffs		Contamination	Out of Sequence
Internal Transport	Poor Information	Crushing		Countersink	Off-set
Tribal Knowledge	Rushing	Heat Treat		Cut Too Short	Mislabeled
LOA	Product Improvement	Wave/Twist in Tube		Instructions Incomplete/Unclear	Fit/Function
Substation	Process Improvement	Marks/Chatter		Drill Holes	Misaligned/off center
Past Expiry Date	Manufacturing Process				Turning Sequence
Misidentified	Past Due	OTHER :			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					